

(Ø)	PLOT SCALE:	1=1	DWG. SCALE:	1	
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8 7 6 5 4 3 2 1

D

C

B

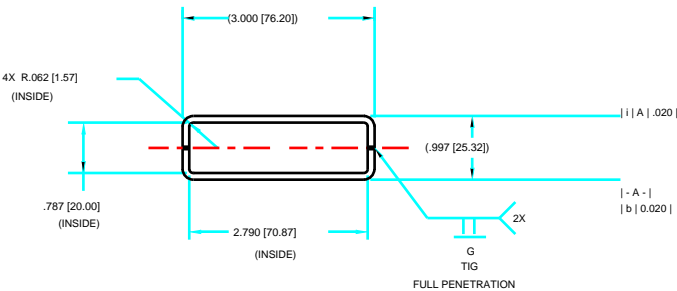
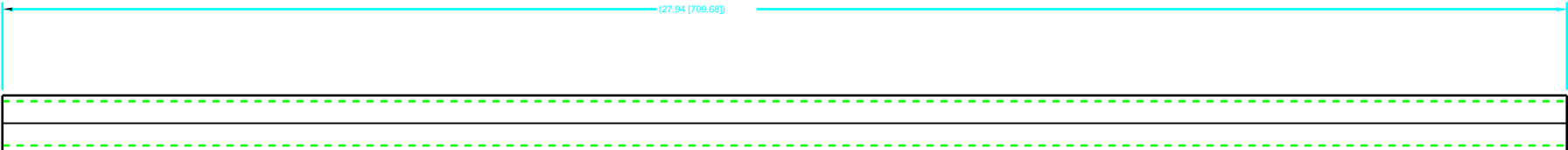
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A



- NOTES:
1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
 2. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
 3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
 4. DIMENSIONS IN [] ARE MILLIMETERS
 5. MAX TWIST ALLOW 2.0mm TOTAL.

01	DIM 27.94 WAS 19.00	R.C.S			
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE	
REVISIONS					

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION		MATERIAL / SPEC	QTY
PARTS LIST					
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES: DECIMALS ANGULAR X - .12 (3.05) - .25 XX - .03 (0.76) - .05 (1.27) XXX - .005 (0.127)					
SURFACE ROUGHNESS 125 /					
REMOVE ALL BURRS AND BREAK SHARP EDGES (R.R.M.)					
SURFACE TEXTURE TO BE IN ACCORDANCE WITH ULTIMATE AND B&I ACCORDANCE WITH LATEST AND Y14.3					
DO NOT SCALE DRAWING					
LOG NUMBER A2262601		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY			
DRAWN BY CORCUERA	DATE 4/25/95	CHIEF DESIGN ENGINEER D.SHU	DATE 4/28/95	TITLE ADVANCED PHOTON SOURCE	
DESIGNED BY T.SANCHEZ	DATE 4/26/95	SP. LEADER T.M.KUZAY	DATE 4/29/95	U2 TRANSITION PIPE 1-ID-B VAC. CHAMBER	
DESIGNER SANCHEZ/CORCUERA	DATE 4/28/95	PROJECT MGR. T.SANCHEZ	APPROVED/RELEASED		
MATERIAL: 12 GA. (.105) 304 STAINLESS STEEL					
SCALE 1=1				SHEET 1 of 1	
DRAWING NUMBER P4105090602-310101-01					

8 7 6 5 4 3 2 1